Work Order ID 99051

March-28-13 10:49:19 AM

99051

Item ID: D3492-1 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID:

Item Name: Plug **Stop** *NS2*

Start Date: 3/27/13 **Start Qty:** 50.00 *50*

Required Date: 3/27/13 **Req'd Qty:** 50.00 *50*

Reference:

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** MLJ **Date:** 13-03-28 **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D3492	D								
100	Hardinge CNC LATHE SMALL	0.00							
100			PO 13/04/03			50	Ø		
Hardinge	**Memo**	0.00							
Hardinge CNC Lathe Small	1-Turn as per Folio FA633 & Dwg D3492 Dwg Rev: D Folio Rev: AA								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110			PO 13/04/03			50	Ø		
QC	**Memo**	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							DAS 04 8-8
120			13.4.3			50	4		
QC	**Memo**	0.00							
Quality Control									

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐
- ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

Work Order ID 99051

99051

March-28-13 10:49:19 AM

Item ID: D3492-1 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Plug

Start Date: 3/27/13 **Start Qty:** 50.00 *50* **Cust Item ID:**

Required Date: 3/27/13 **Req'd Qty:** 50.00 *50* **Customer:**

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Stop** *NR2*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Chemical Conversion Coat per QSI005 4.1	0.00				50			
150									
HandFinish	**Memo**	0.00							
Hand Finishing									
160	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00				50			
160									
Powdercoat	**Memo**	0.00							
Powder Coating	(Flat End Only)								
M125064	START TIME: 9:15								
	OVEN TEMPERATURE: 320°F								
	FINISH TIME: 9:45								
170	QC3- Inspect Part Finish	0.00				50			
170									
QC	**Memo**	0.00							
Quality Control									

3/27/13

BLT

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

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- Work Order Update ☐

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- Skid-tube ☐
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- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐
- ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

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- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

Item ID: D3492-1 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Plug

Start Date: 3/27/13 **Start Qty:** 50.00 *50*
Required Date: 3/27/13 **Req'd Qty:** 50.00 *50*
Reference:

Cust Item ID:
Customer:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Identify as per dwg & Stock Location: FP-001	0.00				x50	6	91	13/4/17
180 Packaging	**Memo**	0.00							
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00						13/4/17	
190 QC	**Memo**	0.00							
Quality Control									

RB 04-17

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

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- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐
- ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

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- ☐ Folio
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- ☐ Hardware
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- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
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- ☐ Outside Dimensions
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- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other _____

Picklist Print

March-28-13 10:49:18 AM

Work Order ID: 99051

Parent Item: D3492-1

Parent Item Name: Plug

Start Date: 3/27/13 **Required Date:** 3/27/13

Start Qty: 50.00 **Required Qty:** 50.00

Comments: IPP Rev:A 11.04.19 per dwg revC DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.625 6061-T6 Round Bar .625"		Purchased	No			100	f	68.4580	**0.0625**	**3.289475**	PO	13/04/03	

Location	Loc Qty	Loc Code	
MAT	67.458		
→ 124681	67.458		3.5
MAT012	1		
120603	1		

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

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- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
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- Engineering ☐
- Quality ☐
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Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

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- ☐ Wrong Stock Pulled
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DART AEROSPACE LTD	Work Order:	99051
Description: Plug	Part Number:	D3492-1
Inspection Dwg: D3492 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

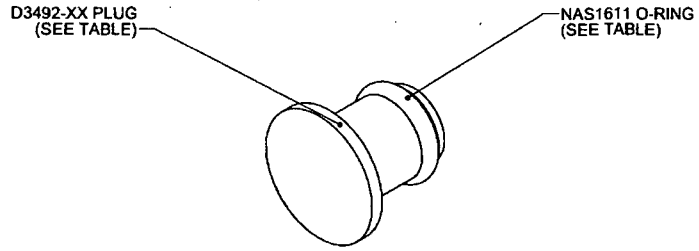
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.060	+/-0.005	.060	✓		VERN	PAD-01
0.060	+/-0.005	.061	✓		"	"
Ø0.394	+/-0.010	.3933	✓		MIC	PAD-02
Ø0.625	+/-0.010	.623	✓		VERN	PAD-01
0.090	+0.000/-0.002	.089	✓		PIN G	
0.500	+/-0.010	.499	✓		VERN	PAD-01
0.050	+0.000/-0.002	.050	✓		"	"
0.050 x 20°	+/-0.010	.050	✓		"	"

Measured by:	PD
Date:	13/04/03

Audited by:	DAS 04 9-89
Date:	13-4-3

Preliminary Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
A	06.06.02	New Issue P/O D3492-041	KJ/JLM	
B	06.10.16	Ø0.625 was Ø0.500	KJ/JLM	
C	07.11.23	Tolerances revised	KJ/EC/DD	
D	08.06.19	0.050 x 20° dimension added	KJ/DD	
E	11.07.26	Dimensions updated per Dwg Rev D	KJ	



D3492-XXX PLUG PARTS LIST

QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	QTY -053	PART NUMBER	DESCRIPTION
X							D3492-041	PLUG ASSEMBLY
	X						D3492-043	PLUG ASSEMBLY
		X					D3492-045	PLUG ASSEMBLY
			X				D3492-047	PLUG ASSEMBLY
				X			D3492-049	PLUG ASSEMBLY
					X		D3492-051	PLUG ASSEMBLY
						X	D3492-053	PLUG ASSEMBLY
1							D3492-1	PLUG
	1						D3492-3	PLUG
		1					D3492-5	PLUG
			1				D3492-7	PLUG
				1			D3492-9	PLUG
					1		D3492-11	PLUG
						1	D3492-13	PLUG
		1					NAS1611-005	O-RING
			1				NAS1611-007	O-RING
1							NAS1611-010	O-RING
						1	NAS1611-012	O-RING
	1						NAS1611-013	O-RING
					1		NAS1611-015	O-RING
				1			NAS1611-016	O-RING

NOTES:
1) O-RING: POSSIBLE SUPPLIER P/N: NAS1611-XXX OR PARKER 2-XXX

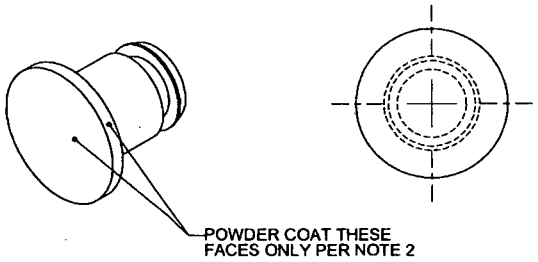
RELEASED
2011 -05- 30

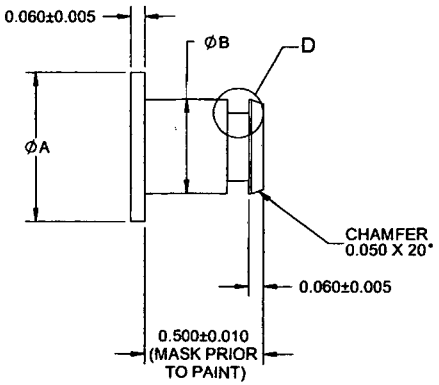
REV.	DESCRIPTION	BY	DATE
D	INCORPORATED DEO D3492-C-1. SHT 2 DIM C FOR -1 WAS 0.055. (SEE CAR11-048)	AJS	11.05.24
C	ADD -049/-051/-053, CHANGE DRAWING FORMAT	PH	07.10.05
B	ADD -047; UPDATE DIM A FOR -045	PH	06.05.11
A	NEW ISSUE	PH	06.01.04

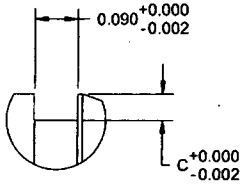
DESIGN	PH	DART AEROSPACE LTD
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. REV. D
MFG. APPR.	J.F.B	D3492 SHEET 1 OF 2
APPROVED		TITLE SCALE
DE APPR.		PLUG 2:1
DATE	11.05.24	

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W/O 99051







DETAIL D

D3492-XX PLUG

D3492-XX PLUG MACHINING DETAILS

P/N	A	B	C	MATERIAL SPEC
D3492-1	0.625	0.394	0.050	M6061T6R0.625
D3492-3	0.750	0.582	0.045	M6061T6R0.750
D3492-5	0.375	0.188	0.045	M6061T6R0.375
D3492-7	0.500	0.270	0.045	M6061T6R0.500
D3492-9	0.938	0.750	0.045	M6061T6R1.000
D3492-11	0.850	0.664	0.045	M6061T6R0.875
D3492-13	0.750	0.510	0.045	M6061T6R0.750

NOTES:
1) MATERIAL: ALUMINUM 5052-H32 OR 6061-T6 OR 1100-0 PER QQ-A-225/7 (5052) OR QQ-A-225/8 (6061) OR QQ-A-200/8 (6061) OR QQ-A-225/1 (1100) (REF. DART MATERIAL SPEC M6061T6R0.000)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: N/A

W/O 99051

RELEASED
2011-05-30

DESIGN	PH	DART AEROSPACE LTD
DRAWN	A.S	HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D3492 REV. D
MFG. APPR.		SHEET 2 OF 2
APPROVED		TITLE PLUG SCALE 4:1
DE APPR.		
DATE	11.05.24	

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